

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 30275		
Estimate Number	: 10400		
P.O. Number	: N/A	Part Number	: D2968043
This Issue	: 1/16/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2968
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29353	Drawing Revision	: B1
		Material	: N/A
Written By	: <u>H. J. O. L. O. L.</u>	Due Date	: 1/30/2007
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF		

1. The first step is to identify the problem. In this case, the problem is that the company is not meeting its sales targets.

2. The second step is to analyze the problem. This involves identifying the causes of the problem and determining the impact of the problem on the company.

3. The third step is to develop a solution. This involves identifying the actions that need to be taken to address the problem and determining the resources that will be required.

4. The fourth step is to implement the solution. This involves putting the solution into action and monitoring the progress of the implementation.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution and determining whether the problem has been resolved.

1.0 30275A STEM



FC 07/08/13 (47)

2.0	30275B	RING
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FC 07/05/15 (47)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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ing 4130 welding rod identify as D2968-043
FC 07 05 15 (47)

40	QC9	VISUAL WELDING INSPECTION
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07/05/15 (47)

5.0 QC5 INSPECT WORK TO CURRENT STEP



1107/05/15 (47)

6.0 PG PURCHASING



(47) 0207/05/17 (47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R Date: 07/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 30275

Part Number: D2968043

Job Number:



Seq. #:

Machine Or Operation:

Description :

Issue P/O: 3797

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

CZ 07105117 (47)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

9/5/06/04 (47)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/20/06 (47) *PTO*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

m 104/44

(31)

FL 07/06/11 (31)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Lu 7/6/12 (31)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 470

7/6/12 (31)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/06/12 (31)

Job Completion



U 07-06-12

Dart Aerospace Ltd

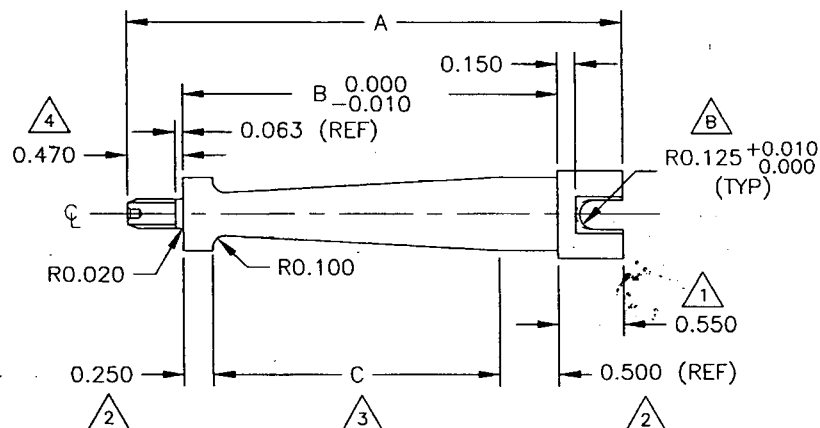
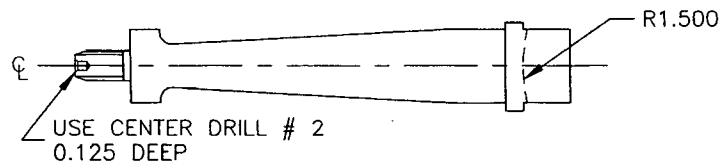
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-06	8.0	16 parts were needed for w/o 32311 D2968-043 for Blue spray paint. 31 remain on this w/o	J	07-06-06	16 31	J 07-06-06	J 07-06-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

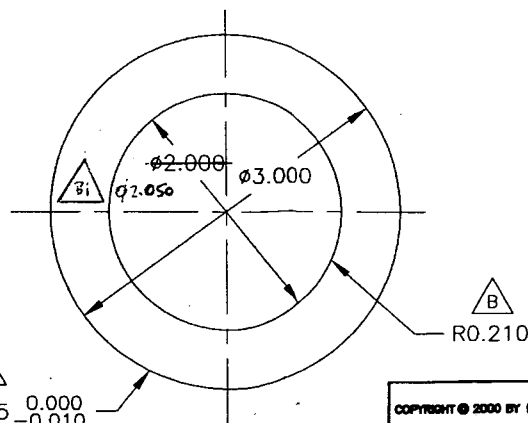
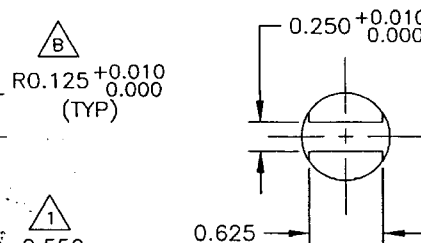
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
 302715
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

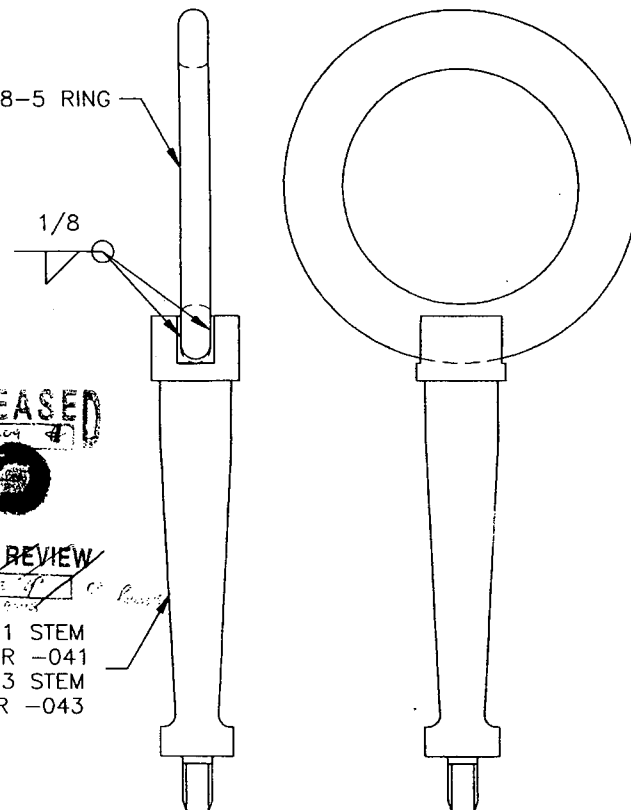


D2968-5 RING

RELEASED

UNDER REVIEW

USE 2968-1 STEM FOR -041
 USE 2968-3 STEM FOR -043



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
 HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
 FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°	
A	00.03.07	NEW ISSUE	
DESIGN	RF	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	RF	DRAWING NO.	D2968
DATE	00.05.31	TITLE	TOW RING
		REV. B	SHEET 1 OF 1
		SCALE	1:1

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GST No.: R105468102

OAK 87554-1

05/28/2007

MM/DD/YYYY

PAGE: 1

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CANADA L6L 2X5
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QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

LL TO:

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST-LAURENT QC

H4T 1K2

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
05/28/2007		
CUSTOMER P/O No.	JOB No.	TERMS
3796		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-043	TOW RING	EA	47	47	
<p>Process Specifications: HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5 MATERIAL: 4130</p> <p>Procedure: 4047</p> <p>B 30275</p> <p><i>[Handwritten Signature]</i></p>					
<p>100% HARDNESS TESTED 47 pcs 30/31 HRC</p> <p><i>[Circular Stamp: V.A.I.O. TH. 25 Q.C.]</i></p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Entered By: CLAVOIE

Total tax

12.00

Total purchase order in

Approved By:

Dact Aerospace Ltd
Client / Customer

D2968-043-B30275
de la pièce / part

103797
Votre # de commande / Your purchase order #

103881
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <i>Bensult</i>		Date, équipe / Date, shift <i>27/05/07</i>	
Placage / Plating <i>QQ1416F CLASS1 T-Rect</i>			
Quantité totale / Total quantity <i>47</i>		Quantité inspectée / Inspected quantity <i>47</i>	
Adhésion / Adhesion <i>Bonne</i>			
Épaisseur / Thickness L.C.D.		H.C.D. Moy. / aver. <i>0.0015</i>	
Coulisses, taches / Leach, spots <i>No</i>		Rugosité / Roughness <i>No</i>	
Quantité approuvée / Approved quantity <i>47</i>		Quantité rejetée / Rejected quantity	

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX